






Date: Friday, 1/6/2006 1:48:15 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH								
Job Number	: 25410A										
Estimate Number	: 11703										
P.O. Number	: N/A	Part Number	: D2724042								
This Issue	: 1/6/2006	S.O. No.	: N/A								
Prsht Rev.	: NC	Drawing Number	: D2724 REVC								
First Issue	: N/A	Project Number	: N/A								
Previous Run	: N/A	Drawing Revision	: C								
Written By	: SEE COMMENT BELOW	Material	: N/A								
Checked & Approved By	: SEE COMMENT BELOW	Due Date	: 1/13/2006								
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM	Qty:	3 Um: Each								
Additional Product											
Job Number: 											
Seq. #:	Machine Or Operation:	Description :									
1.0	D2622120C	Extrusion									
											
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part #</th> <th>Description</th> <th>Batch:</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2622-120C</td> <td>Extrusion</td> <td><u>324092</u></td> </tr> </tbody> </table> <p>Check Material for any Dents or Defects</p> <p style="text-align: right;"><i>L.L. 06.01.10</i></p>				Qty	Part #	Description	Batch:	1	D2622-120C	Extrusion	<u>324092</u>
Qty	Part #	Description	Batch:								
1	D2622-120C	Extrusion	<u>324092</u>								
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1									
											
<p>Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs</p> <p>LARGE FABRICATION RESOURCE 1</p> <p>Cut D2724-2 using D2622 extrusion as per Dwg D2724</p> <p>Deburr and bevel ends for welding</p> <p style="text-align: right;"><i>LE 06.01.10</i></p>											
3.0	D2734	206 Step Endplate									
											
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)</p> <p>206 Step Endplate</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2734</td> <td>End Cap</td> <td><u>320757</u></td> </tr> </tbody> </table> <p style="text-align: right;"><i>LE 06.01.10</i></p>				Qty	Part Number	Description	Batch	2	D2734	End Cap	<u>320757</u>
Qty	Part Number	Description	Batch								
2	D2734	End Cap	<u>320757</u>								
4.0	D34581	PLATE									
											
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)</p> <p>Pick:</p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3458-1</td> <td>Plate</td> <td><u>325418 = 5 pcs</u> <u>325209 = 1 pcs</u></td> </tr> </tbody> </table> <p style="text-align: right;"><i>LE 06.01.10</i></p>				Qty	Part Number	Description	Batch	2	D3458-1	Plate	<u>325418 = 5 pcs</u> <u>325209 = 1 pcs</u>
Qty	Part Number	Description	Batch								
2	D3458-1	Plate	<u>325418 = 5 pcs</u> <u>325209 = 1 pcs</u>								

325418
325209

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Drawing Name: 206L /407 STEP ASSY, RH

Part Number: D2724042

[illegible]

Description :

PLATE

[illegible]

(b) (7)(C), (b) (7)(D)

Pick:

Description

Batch

2 D3458-3

Plate 325210 = 16 325417 = 2

16. 06.01.10

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

[illegible]

██████████

LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig DT (One End Only)

A/R AL ROD Batch: m/1838 m/1839

Grind end cap welds flush

06.01.11

QC5/9

WELD INSPECTION

[illegible][illegible]

WELD INSPECTION

PD 06-01-11
06-01-11

HAND FINISHING1

HAND FINISHING RESOURCE #1

[illegible]

HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-01-11 3:

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

[illegible][illegible]

INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-11

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

[illegible]

11-11-11

LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 25410A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT

A/R AL ROD Batch: m12839

Handwritten: J-E 06-01-11

3

11.0

QC5/9

WELD INSPECTION



Handwritten: PD/ J-E 06-01-11



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
WELD INSPECTION

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
HAND FINISHING RESOURCE #1

Touch up Alodine

Handwritten: FF 06-01-12

3

13.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: ml 06-01-15 3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
Wing Walk as per Dwg D2724 and QSI 00 5 4.4

Handwritten: ml 06-01-15 3

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: C Log 01/18 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock

Handwritten: C Log 01/18 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 25410A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Location:

18.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

SP 06/01/18

Job Completion



U 06.01.18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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